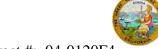
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453

(707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-022132 Address: 333 Burma Road **Date Inspected:** 24-Mar-2011

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes Li Yang No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

Bridge No: 34-0006 **Component:** Orthotropic Box Girder (OBG)

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

WELDING:

Cross Beam 17

This QA Inspector observed ZPMC qualified welding personnel identified as 040673 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CB3001A-017-002; located On Orthotropic Box Girder (OBG) Deck Plate to Side Plate CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Li Yang. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. The Welding Repair Report (WRR) was B-WR20402. ZPMC Quality Control (QC) Mr. Li Yang was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW-4G (4F) FCM-Repair-1. See attached photo for further details.

Segment 12AE

This QA Inspector observed ZPMC qualified welding personnel identified as 067752 perform Shielded Metal Arc

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welding (SMAW), weld joint identified as OBE12C-029; located On Orthotropic Box Girder (OBG) Edge Plate to Cantilever Bracket Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. This QA Inspector observed the base material appears to have been preheated by a torch prior to welding. ZPMC Quality Control (QC) Mr. Wang Li Yang was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-TC-U4b-FCM-1. See attached photo for further details.

Segment 12BE

This QA Inspector observed ZPMC qualified welding personnel identified as 044504 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE12C-022; located On Orthotropic Box Girder (OBG) Edge Plate to Cantilever Bracket Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. This QA Inspector observed the base material appears to have been preheated by a torch prior to welding. ZPMC Quality Control (QC) Mr. Wang Li Yang was onsite monitoring the welding variables. The welding variables recorded by OC appeared to comply with applicable WPS-B-P-2214-TC-U4b-FCM-1.

NDT:

Segment 12AE

This QA Inspector performed Magnetic Particle Testing (MPT) Verification Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report on this date. The members are identified as Orthotropic Box Girder (OBG) components. The weld designations Verified are as follows.

SEG3006M-134

CA3010C-062

DP3070-001-191

CA3010-015

CA3010C-037

SEG3006H-132

CA3010D-061

DP3070-001-133

FB3091-001-011

CA3010D-153

SEG3006K-131

CA3010C-262

DP3070-001-158

CA3010C-214

FB3089-001-085

CA3010C-282

Nondestructive testing (NDT) notification No.08612

DCP:

Segment 12W

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This Quality Assurance (QA) Inspector witnessed final tension verification for Cable Tray Bottom Plate at Panel Point (PP) 109 and PP 117 for Segment 12W. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00630 Dated March 24, 2011.

Bolt sizes used were M20 x 55 DHGM200038 and final torque required was 280 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-114.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.





Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer